

FCAW

# DW-308L

**PREMIARC™**

## Flux cored wire

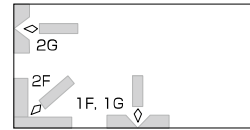
**Features:** ▪ Applied for 304L type steel

**Classification:** AWS A5.22 E308LT0-1/4

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub>

**Polarity:** DCEP

### Welding Positions:



## Packaging data

φ mm	Spool	
	0.9	5kg
1.2	-	12.5kg
1.6	-	12.5kg
<b>Volume mm</b>	235W, 110H, 230L	295W, 110H, 295L

## Composition (all-weld metal mass%)

	Typical (CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.6	1.0
<b>Mn</b>	1.5	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	10.0	9.0~11.0
<b>Cr</b>	19.5	18.0~21.0
<b>Mo</b>	0.02	0.75
<b>Cu</b>	0.03	0.75
<b>Bi</b>	>0.002	-

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G
0.9	80~150	90~130
1.2	130~270	150~220
1.6	190~320	220~270

## All-weld mechanical properties

	Typical (CO <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	370	-
<b>TS (MPa)</b>	550	518min.
<b>EI on 4d (%)</b>	42	30min.
<b>IV 0°C (J)</b>	41	-

## Approvals

<b>ABS</b>	MG
<b>LR</b>	304L S (CHEM & CRYO)
<b>DNV-GL</b>	VL308L, MG (CO <sub>2</sub> ) VL308L (Ar-CO <sub>2</sub> )
<b>NK</b>	KW308LG (C)
<b>CWB</b>	E308LT0-1, E308LT0-4

Note: CO<sub>2</sub>, except in CWB/DNV-GL